

## CLAIMS

1           1.     A method for creating a three-dimensional engraving,  
2     comprising the steps of:  
3           providing a three-dimensional solid having a specified shape and size;  
4           scanning, into a processor driven and numerically controlled machining  
5     center, data corresponding to a three-dimensional illustration;  
6           projecting, into said solid, said three-dimensional illustration;  
7           machining, in three-dimensional fashion, a three-dimensional surface  
8     within said solid corresponding to said illustration; and  
9           shading said three-dimensional surface of said solid according to  
10    selected depths of machining.

1           2.     The method as described in claim 1, further comprising the step  
2     of surface preparing said three-dimensional solid prior to machining.

1           3.     The method as described in claim 1, further comprising the step  
2     of forming recessed surfaces on a non-machined surface of said solid.

1           4.     The method as described in claim 1, further comprising the step  
2     of securing fastener receiving mounting studs to a non-machined surface.

1           5.     The method as described in claim 4, said step of securing studs  
2     further comprising welding incorporating a capacitor discharge arcing process.

1           6.     The method as described in claim 1, said step of projecting said  
2     three-dimensional illustration further comprising assigning a depth of cut per  
3     pixel distributed across a selected machining area.

1           7.     The method as described in claim 3, further comprising the step  
2     of locating said solid upon a machining center platform according to a location  
3     of said recessed surfaces.

1           8.     The method as described in claim 1, said step of machining  
2     further comprising machining a roughing cut in a first direction, and  
3     subsequently machining a finishing cut in a second direction.

1           9.     The method as described in claim 1, said step of shading further  
2     comprising immersing said machined three-dimensional solid within an oxide  
3     bath.

1           10.    The method as described in claim 9, further comprising the step  
2     of applying a neutralizing solution to said solid following said step of  
3     immersing.

1           11.    The method as described in claim 10, said step of shading  
2     further comprising abrading said three-dimensional surface and in order to  
3     remove a darkened coating resulting from said oxide bath.

1           12.    The method as described in claim 1, further comprising the step  
2           of environmentally coating said machined solid.

1           13.    The method as described in claim 12, said step of coating  
2           further comprising applying a powderized and thermosetting acrylic urethane  
3           material.

1           14.    The method as described in claim 13, further comprising the  
2           step of baking said powder coated solid in an oven.

1           15.    The method as described in claim 1, said step of machining  
2           further comprising engraving said solid.

1           16.    The method as described in claim 6, said step of assigning a  
2           depth of cut per machining area further comprising assigning 200 pixels per  
3           square inch of area.

1           17.    The method as described in claim 6, said step of assigning a  
2           depth of cut further comprising establishing a scale of 0-255 projected into an  
3           intermediate location of said solid.

1           18.    A solid exhibiting a three-dimensional engraved surface,  
2           according to the following steps:

3 scanning, into a processor driven and numerically controlled machining  
4 center, data corresponding to a three-dimensional illustration;  
5 projecting, into said solid, said three-dimensional illustration according  
6 to a depth of cut per pixel distributed across a selected machining area;  
7 machining, in three-dimensional fashion, a three-dimensional surface  
8 within said solid corresponding to said illustration, said step of machining  
9 further comprising at least machining a roughing cut in a first direction and  
10 subsequently machining a finishing cut in a second direction;  
11 immersing said machined solid into an oxide bath;  
12 abrading a darkened coating formed by said oxide bath upon said three-  
13 dimensional surface and in order to shade said solid according to individual  
14 depths of cut;  
15 applying a powderized and plasticized material upon said solid; and  
16 baking said powder coated solid in an oven and in order to thermoset said  
17 powderized material.

1 19. The solid as described in claim 18, further comprising the step  
2 of forming recessed locating surface on a non-machined surface of said solid.

1 20. The solid as described in claim 18, further comprising the step  
2 of securing fastener receiving mounting studs to a non-machined surface of  
3 said solid according to a capacitor discharge arc welding process.